

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005833**Date Inspected:** 24-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Chung Fu Kuan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date, 3/24/09, Caltrans OSM Quality Assurance (QA) Inspector Mike Brcic was present during the times noted above for observations relative to the work being performed on castings, in either the Fabrication shop #4 or Foundry Shop at Japan Steel Works.

W2E3 - Casting is sitting idle in Fab Shop #4, its "soon to be joined" built up section is having its "milled to bear" surface scribed / marked for an appropriate land.

W2W1 - The valley of the trough appeared to have been prepared to have Ultrasonic Testing due to couplant having been placed intermittently along it, (no technician around to verify process and/or procedure).

W2W2 - West Deviation Casting is still waiting shot blast.

W2W3 - Repair welding pending on Casted Section.

T1-3 - Measuring in progress to confirm enough surfacing has been deposited on Buttered joint 9W-3U (two layer minimum has been met). Welders assigned, but not yet welding, were K. Iwamoto, ID 07-4366, and D. Hirokawa 08-3566 utilizing WPS SJ3012-1-1, CWI, Chung Fu Kuan, was available during QAI walk-through, preheat was verified at surface (tested between 1 and 3 inches from two of buttering) utilizing a Tempilstick in excess of 160 degrees Celsius (requirement is 150 Celsius), heated portable rod quivers are in use to maintain "oven" temperatures.

E2E1 - Shaping function in progress, Carbon Arcing method employed.

E2W1 - Mechanical grinding of carbon arc surface to casting in progress, approximately 35% complete.

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Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

Summary of Conversations:

Spoke with SMR Ms Nina Choy regarding PJP land having been exposed to weld ends at edge of butt joint. Ms Choy cleared the issue as having no detriment to future serviceability of these typical joints. This now closes the loop on the indications noted on MPT report TL-6028 dated 3/10/2009 (MPT-mbrbic-000002).

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brcic,Michael	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
